

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011095**Date Inspected:** 11-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Wang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Heavy dock –Jetty

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 205524 perform FCAW Tack welding on, inside bearing plate stiffener in Skin D, of south tower, lift 1, weld joint identified as SSD1-SA 40 B/E-19. ZPMC CWI Identified as Mr.Wang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2313-TC-P4-F.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 206568 perform FCAW Tack welding on, inside bearing plate stiffener in Skin B, of south tower, lift 1, weld joint identified as SSD1-SA 18-8, 9. ZPMC CWI Identified as Mr.Wang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2313-TC-P4-F.

3.This QA inspector, Baskar Govindarajan, observed, diagonal readings in all corners of West shaft, lift 1 after welding with base plate as follows, AB corner -99 mm(Side A) and 100 mm (Side B); BC corner -99 mm(Side B) and 101 mm (Side C); CD corner -99 mm(Side C) and 99 mm (Side D); DE corner -102 mm(Side D) and 101 mm (Side E); EA corner -100 mm(Side E) and 99 mm (Side A)

4.This QA inspector, Baskar Govindarajan, observed, after erection of North tower, Lift 1, by ZPMC personnel's,

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a gap of approximately 5 mm between stiffener and base plate inside the shaft of Skin C. Photograph attached.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
